

Date: Tuesday, 23/12/2008 3:30:39 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE			
Job Number	: 44318						
Estimate Number	: 11177						
P.O. Number	:			Part Number	: D2281		
This Issue	: 23/12/2008	S.O. No.	:	Drawing Number	: D2281 REV G		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type	: SMALL /MED FAB			
Previous Run	: 43742			Drawing Revision	: G		
Written By	:			Material	:		
Checked & Approved By	: <u>WLF</u> 08-12-24			Due Date	: 20/01/2009		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM			Qty:	100	Um: Each	
	Est: rev B 06.07.17 waterjet EC.						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS sheet .080
		Comment: Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s) 304SS .080 <u>109358</u> batch: <u>109358</u> <u>LB 9-1-14</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> <u>LB 9-1-14</u> Prog Rev: <u>G</u>
		<u>110</u>
		2-Deburr if necessary <u>LB 9-1-14</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>LB 9-1-14</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>8 09 01 15</u> <u>+110</u> <i>cancel</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<u>MAS</u>
		Comment: Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 3:30:39 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 44318

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SP 09/01/15 110

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/01/15 110

8.0 PACKAGING 1

PACKAGING RESOURCE #1



110X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ~~Shuttle Cen~~

9/1/15

SP

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/16 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44318
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

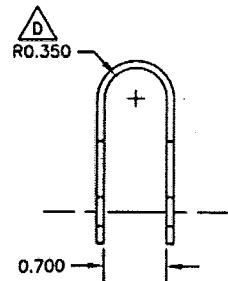
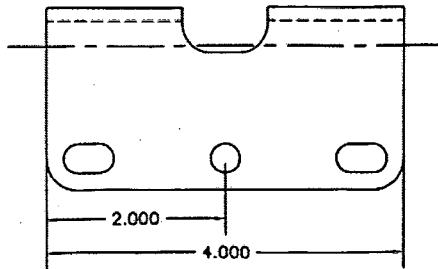
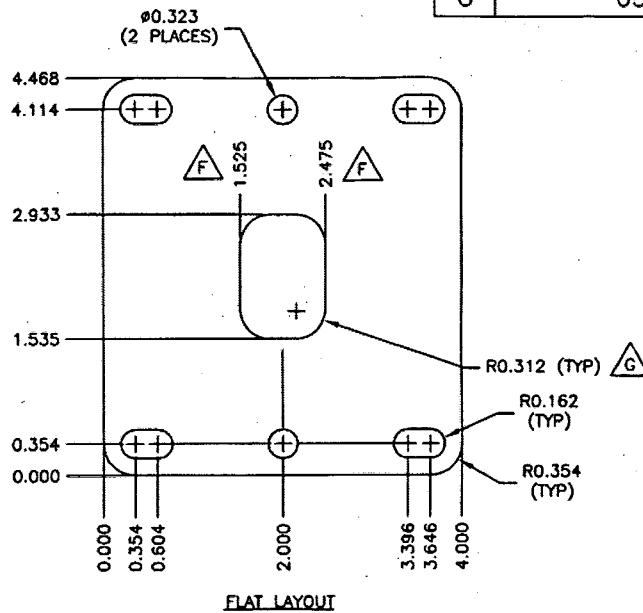
Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 9-1-14	Date: 09/04/15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>MMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
MMS
05/08/11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44318

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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18